

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010414**Date Inspected:** 22-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6AW)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Longitudinal Girder weld of 6AW-PP38. The weld designations reviewed are as follows:

SEG027M-018

OBG # TRIAL ASSEMBLY YARD

This QA inspector measured and recorded root gap and offset with QA inspector (Mr. Manjunath) for below segment. Reports forwarded to team leader for further action.

5CE-6AE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (2AW-2BW)

WELDING INSPECTION REPORT

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SMAW Process:

Welding of weld joint – 006 located on PCMK CA102 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 054013. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint – 004 located on PCMK CA102 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 067609. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (2AE)

SMAW Process:

Welding of weld joint – 007 located on PCMK SEG010A of longitudinal diaphragm weld connecting bottom panel and side panel of 2AE (Crossbeam side, E4). Welder is identified as 067942. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF Ultrasonic report, UT-2E-007-R1. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned dimensional discrepancy observed in 5BE. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
